

* Date: Wednesday, 12/20/2006 11:59:11 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
Job Number : 29994
Estimate Number : 10288
P.O. Number : N/A
This Issue : 12/20/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL / MED FAB
Previous Run : 29488
Written By :
Checked & Approved By :
Comment : Est: E 02.09.24 Re-format; Incorporated D2577-101/-11 KJ/
RF
est F 06.09.11 now waterjet EC

Part Number : D25771
Drawing Number : D2577 REV E
Project Number : N/A
Drawing Revision : E
Material : N/A
Due Date : 1/10/2007 Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S16GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.8474 sf(s)/Unit Total: 33.8940 sf(s)
1010/1025/A21/6aA SHEET M103788

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2577 (D2577-101 detail)

Dwg Rev: E

Prog Rev: E

M1 07 03 15

40

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M1 07 03 15

40

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07/03/19 40

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179

2-Form joggle as per Dwg D2577 using DT8157

3-Identify as D2577-1

4-Deburr if nesasary

MF.
SB

07-03-23

07 103 / 20

07 103 / 22

40
40

40

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/04/11
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 11:59:11 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 29994

Part Number: D25771

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/26

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description

Batch

A/R 7560 Hardcoat Rod

mp33724

FC 07/04/05 (29)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/05 (29)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m10/601

FL 07/04/10 (29)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-l 07/04/11 (29x)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP18

m-l 07/04/11 (29x)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/11 (29)

Job Completion



W 07/04/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

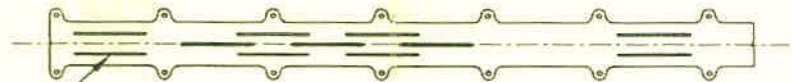
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

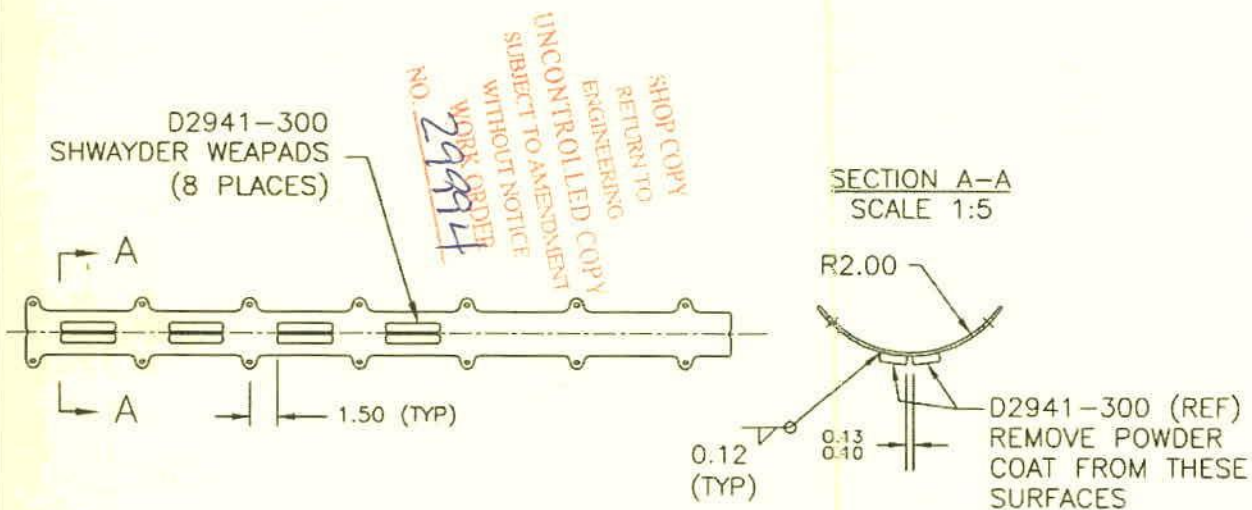
DART**RELEASED**
00 09 26 97

| DESIGN | DRAWN BY | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA | REV. E |
|------------------|-------------------|---|--------------|
| CHECKED | APPROVED | DRAWING NO. D2577 | SHEET 1 OF 5 |
| DATE 00.09.22 | TITLE WEARSHOE | SCALE 1:10 | |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.04 | ADD HARDCOAT WELDS | |
| C | 97.05.30 | CHANGE HOLES TO OBOUNDS | |
| D | 98.08.17 | CORRECTED DIMENSIONS ON -1 & -3 | |
| E | 00.09.22 | ADD D2577-101/-11/-13 INCORPORATE DE09176 | |

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



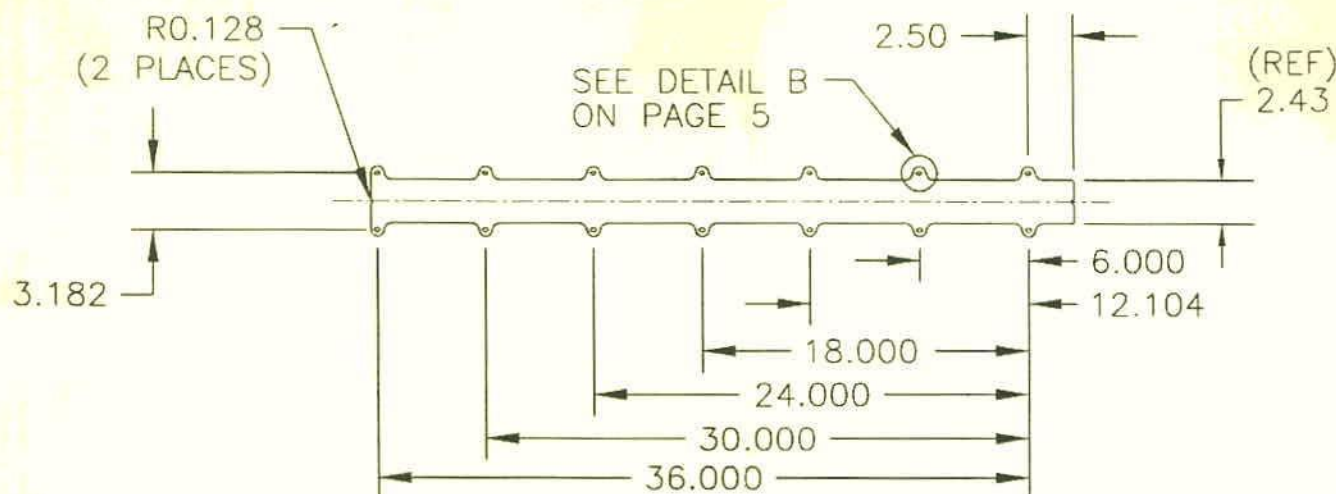
D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

| DESIGN | DRAWN BY | DRAWING NO. | REV. E |
|----------|----------|-------------|--------------|
| | | D2577 | SHEET 2 OF 5 |
| CHECKED | APPROVED | TITLE | SCALE |
| DATE | | WEARSHOE | 1:10 |
| 00.09.22 | | | |

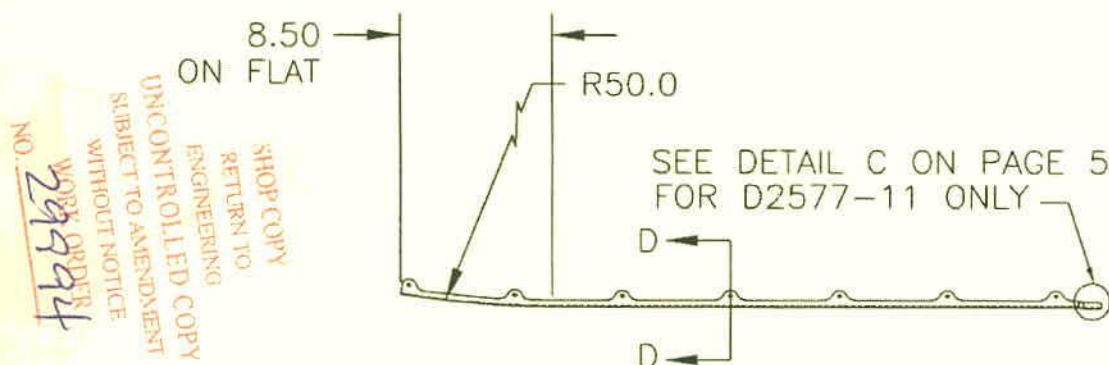
RELEASED
00 09 26 #**D2577-101 FLAT PATTERN**

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2577-11 & D2577-13 LONGITUDINAL BEND**

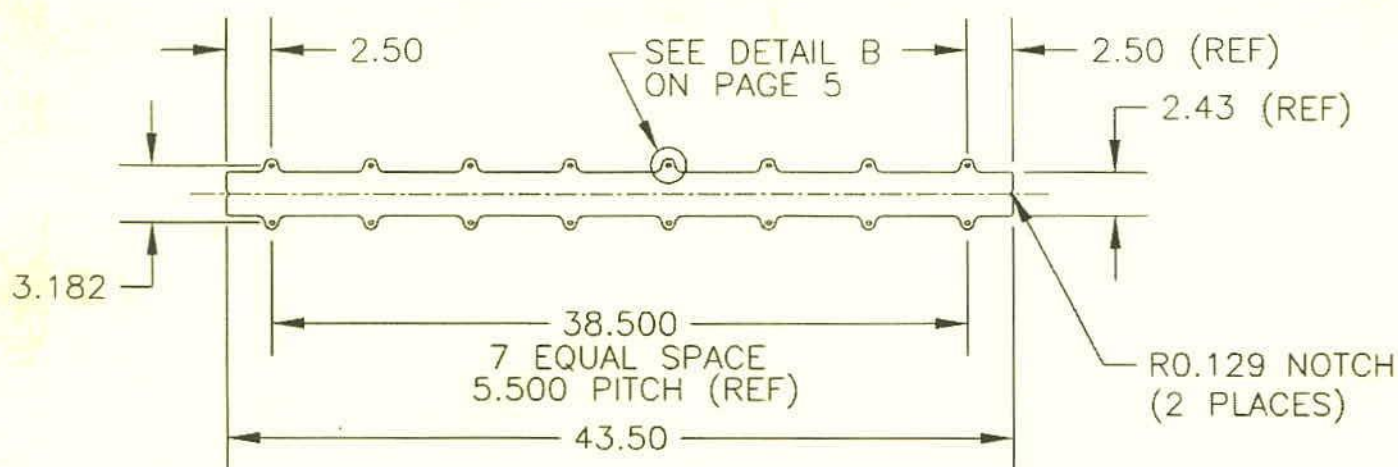
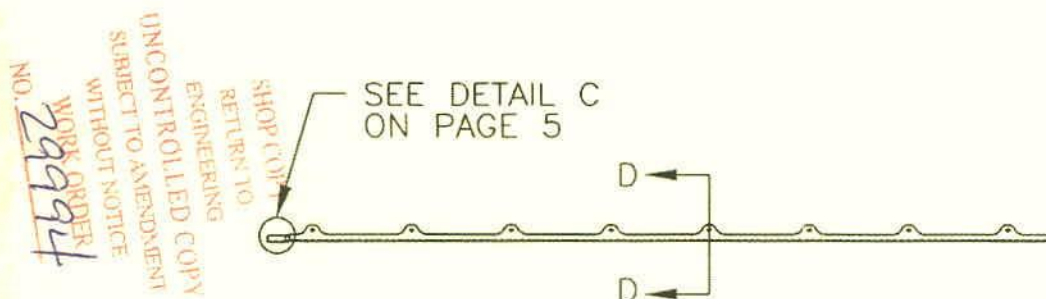
MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29994

DART

| | | | | |
|---------|----------|----------|----------|---|
| DESIGN | ✓ | DRAWN BY | CP | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA |
| CHECKED | ✓ | APPROVED | ✓ | DRAWING NO. D2577 |
| DATE | 00.09.22 | TITLE | WEARSHOE | REV. E SHEET 3 OF 5 |
| | | SCALE | 1:10 | |

RELEASED
00.01.26D2577-5 FLAT PATTERND2577-5 LONGITUDINAL BENDD2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1870

1871

1872

1873

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1875

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1877

1878

1879

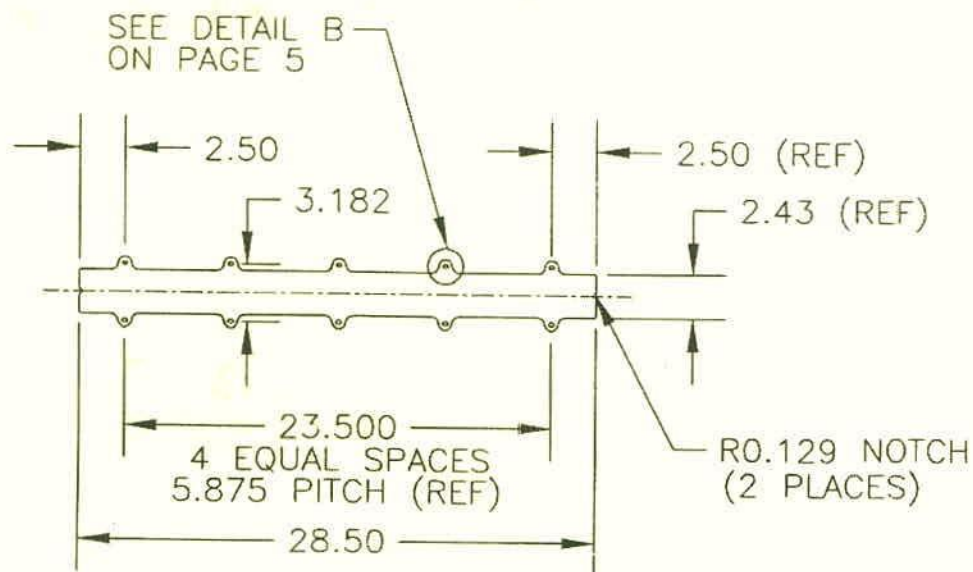
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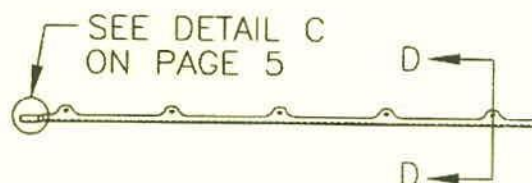
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|------------------|----------|--|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAMMERSBURG, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D2577 |
| DATE 00.09.22 | | TITLE WEARSHOE |
| | | REV. E SHEET 4 OF 5 SCALE 1:10 |

RELEASED
00 09 26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



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D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

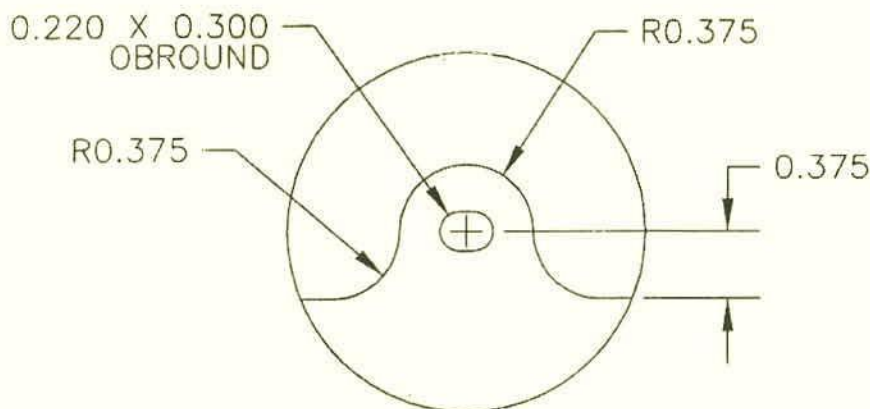
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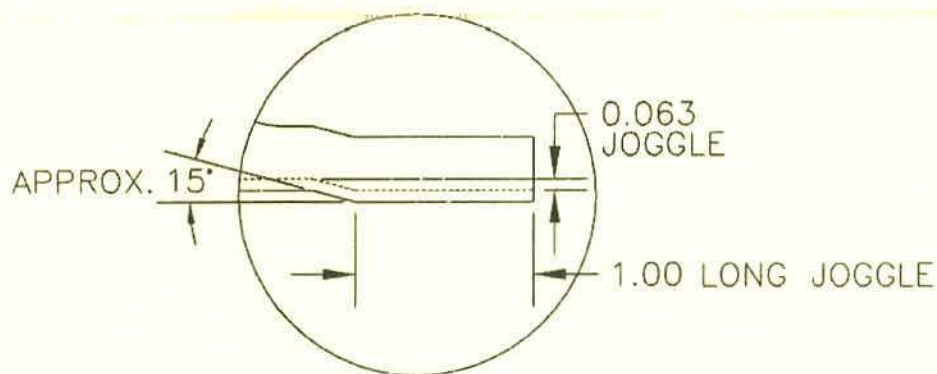
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|------------------|----------------|---|------------------------|
| DESIGN # | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2577 | REV. E SHEET 5 OF 5 |
| DATE 00.09.22 | | TITLE WEARSHOE | SCALE 1:10 |

DETAIL B (SCALE 1:1)

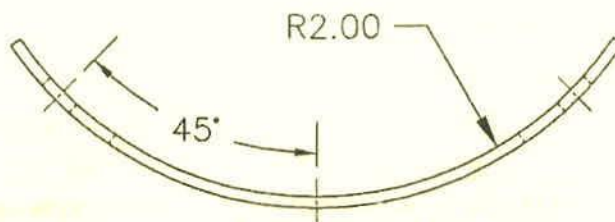
RELEASED
00.09.26



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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WORK ORDER
NO. 29994

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| | | |
|------------------------------------|--------|----------------------|
| DART AEROSPACE LTD | | Work Order: 29994 |
| Description: ---, <u>Wearplate</u> | | Part Number: D2577-1 |
| Inspection Dwg: D2577 | Rev: E | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|---|---------------------|--------|--------|-------------------------|----------|
| A | Inspected as per template D2577 = $\frac{1}{3}$ | | ✓ | | | |
| B | | | | | | |
| C | | | | | | |
| D | | | | | | |
| E | | | | | | |
| F | | | | | | |
| G | | | | | | |
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| | | | |
|---------------------------|--------------------------------|---------------------|------------|
| Measured by: <u>mm mm</u> | Audited by: <u>[Signature]</u> | Prototype Approval: | N/A |
| Date: <u>07/03/15</u> | Date: <u>07/03/19</u> | Date: | N/A |
| Rev | Date | Change | Revised by |
| | | New Issue | KJ/RF |
| | | | Approved |

